

Work Order ID 63934

Friday, November 19, 2010 11:10:14 AM

Page 1

Item ID: D350-591-133

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Maintenance Step

Start Date: 11/22/2010 Start Qty: 2.00

Required Date: 12/3/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MFDate: 0-11-19

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2946

Rev B

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-133 CHG003

M 10 12 10 (2)
HA for CL 10/12/8

110

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

12.11.30 2 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Item Name: Aft Maintenance Step

Start Date: 11/22/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
				10.12.02		(12)			
160 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				2			
				10.12.02					
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2			
				10.12.02					

W/O:		WORK ORDER CHANGES					
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Page 5

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Required Date: 12/3/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 10-12-7.

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:10

OVEN TEMPERATURE: 320

FINISH TIME: 11:40

2 BR 10-12-7.

230

Wing Walk as per dwg QSI005 4.4 Batch M113796

0.00



HandFinish

Memo

0.00

Hand Finishing

= 11 10/12/07

2 f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Accept 10 (2)

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Accept 10 (2)

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

M 10 12 10 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-133

Location: _____

PPP Rev: _____

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

ME

10-12-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, November 19, 2010 11:10:14 AM

Page 1

Work Order ID: 63934

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step



Start Date: 11/22/2010

Required Date: 12/3/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
IPP Rev:B 06.07.19 D2946 @ rev.b EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																																				
AN4-11A Bolt X2		Purchased	No			250	Each	330.0000	4	8																																																																																							
<table border="0"> <tr> <td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td colspan="11"></td></tr> <tr> <td>ST357</td><td>330</td><td></td><td colspan="11"></td></tr> <tr> <td>110382</td><td>130</td><td></td><td colspan="11"></td></tr> <tr> <td>115316</td><td>200</td><td></td><td colspan="11"></td></tr> </table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>												ST357	330													110382	130													115316	200																																								
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4

116382

M115936

M115374 16

C 11/12/9 (2)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, November 19, 2010 11:10:14 AM

Work Order ID: 63934

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 11/22/2010

Required Date: 12/3/2010

Start Qty: 2.00

Required Qty: 2.00



AN4-7A
Bolt

Purchased No

250 Each

146.0000



4

[Handwritten signature]

Location

Loc Qty

Loc Code

ST356

146

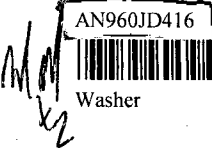
113226

96

115373

50

M113226



AN960JD416
Washer

NAS1149D0463J

Purchased No

250 Each

24.0000



14

28

M116289

[Handwritten signature]

Location

Loc Qty

Loc Code

ST300

24

113288

24

Location

Loc Qty

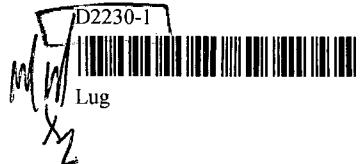
Loc Code

ST476

36

62665

36



D2230-1
Lug

Manufactured No

250 Each

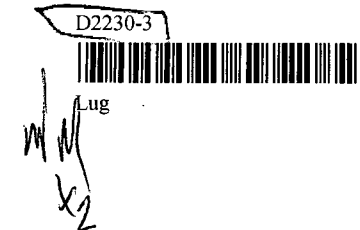
36.0000



4

8

62665



D2230-3
Lug

Manufactured No

250 Each

24.0000



4

8

63992

[Handwritten signature] (2)

Location

Loc Qty

Loc Code

ST476

24

55452

2

62927

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, November 19, 2010 11:10:14 AM

Page 3

Work Order ID: 63934

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 11/22/2010

Required Date: 12/3/2010

Start Qty: 2.00

Required Qty: 2.00

D2622-120C

Manufactured No

110 Each

74.8200 0.52 1.04



Step Extrusion



10.11.30

Location

Loc Qty

Loc Code

WA

74.82

55214

3.42

58544

1

61208

70.4

Manufactured No

250 f

12.4993



1.04

[Signature]

Location

Loc Qty

Loc Code

ST412

12.499279

56516

12.499279

56516

cut (8) at 3.00"

D2734

Manufactured No

130 Each

64.0000 2 4



Step End Plate



10.11.30

Location

Loc Qty

Loc Code

WA

64

61209

19

62931

45

Manufactured No

250 f

327.8530 1.26 2.52



4

12/12/10 (2)

D2856-400



Abraison Strip

Location

Loc Qty

Loc Code

ST403

327.8530421

56626

0.00004211

59920

111.853

63735

216

59920

(2X) 4.00" X 7.20" per dwg

Friday, November 19, 2010 11:10:14 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Friday, November 19, 2010 11:10:14 AM

Work Order ID: 63934

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Start Date: 11/22/2010

Required Date: 12/3/2010

Start Qty: 2.00

Required Qty: 2.00

D2944

Manufactured No

130

Each

5.0000

2

4



Step Mounting Plate



10-11-30

Location

Loc Qty

Loc Code

WA

B64082

5

53725

5

Manufactured No

250

Each

10.0000

1

2



Step Mounting Plate



43

Go

Location

Loc Qty

Loc Code

ST031

10

55064

10

Purchased No

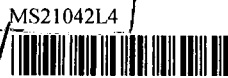
250

Each

5,703.000

14

28



Nut



55064

12/12/9 @

Location

Loc Qty

Loc Code

ST300

5703

113422

25

114523

8

115589

1070

115621

1100

116188

3500

m115589

Friday, November 19, 2010 11:10:14 AM

Shop Packet Print

Page 4

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DART

D2946 STEP ASSEMBLY PARTS LIST

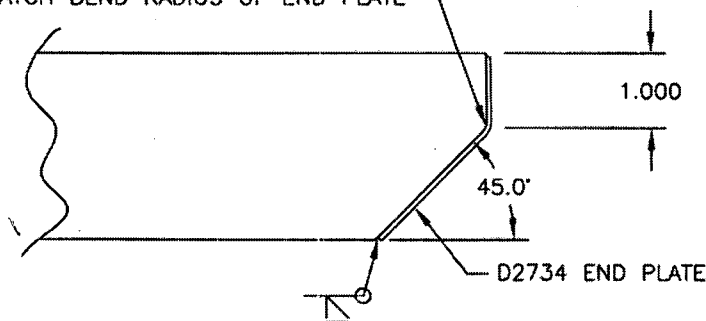
Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

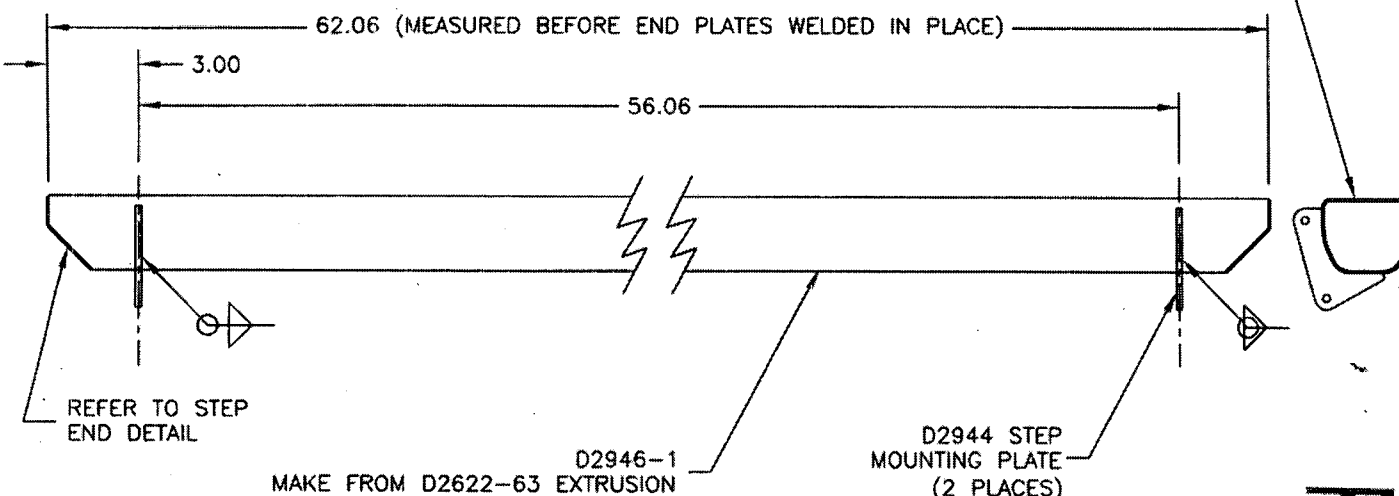
NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE LTD HAMMERSBURG, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2946
DATE	05.11.14			TITLE STEP ASSEMBLY
	A	99.12.13	NEW ISSUE	REV. B
	B	05.11.14	UPDATE FINISHING NOTE	SHEET 1 OF 1
				SCALE 1:6

RELEASED
05-11-28

10/12/10

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	Heli-Access-Step ™, Long Step – High Skid
	X					D350-591-113	Heli-Access-Step ™, Short Step – High Skid
		X				D350-591-115	Heli-Access-Step ™, Short Step – Low Skid
			X			D350-591-117A	Heli-Access-Step ™, Pre-Flight Step
				X		D350-591-119	Heli-Access-Step ™, Long Step – Low Skid
					X	D350-591-133	Heli-Access-Step ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-122	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-123	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-124	Heli-Access-Step ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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